

Date: Wednesday, 17/09/2008 10:46:30 AM  
User: Jean-Luc Menard

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : HINGE  
Job Number : 42054  
Estimate Number : 13569  
P.O. Number :  
This Issue : 17/09/2008 S.O. No. :  
Prsht Rev. : NC Part Number : D38141  
First Issue : // Type : MACHINED PARTS Drawing Number : D3814 PREL  
Previous Run : Material :  
Written By : JLM 09.17 Due Date : 24/09/2008 Qty: 3 Um: Each  
Checked & Approved By :  
Comment : Est Rev:A New Issue 08-09-03 JLM Verified By:EC

Additional Product

FOR ENGINEERING USE ONLY

~~PRELIMINARY ISSUE~~

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B2000X04500 6061T6 Bar 2.00 x 4.500



Comment: Qty.: 0.6300 ft(s)/Unit Total : 1.8900 ft(s)

6061-T6 Bar 4.00" x 1.00" 2.00 x 4.500"

BATCH: M109425

JLM 08/10/02

(2)

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut blank 7.100" long

JLM 08/10/02

(3)

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA780 Rev: AA &amp; Dwg D3814 Rev: A

2-Deburr per dwg D3814

3-Finish tapping hole to final depth as per Dwg D3814

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(3)

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

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(3)

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

JLM 08/10/02

(2)

# Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HINGE

Job Number: 42054

Part Number: D38141

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*MJ*

*08-10-03*

*(2X)*

7.0 POWDER COATING

POWDER COATING



*M109152*



*(2X)*

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

~~\*\*\*MASK THREADED HOLE PRIOR TO POWDER COAT\*\*\*~~

*N/A*  
*08-10-03*

START TIME:

*11:00*

OVEN TEMPERATURE:

*320°F*

FINISH TIME:

*11:30*

*MJ 08/10/03*

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

*AS 08/10/03 (2X)*

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*Harvey*

POSITIVE RECALL

EFFECTIVE *08.09.17*

RELEASED

AUTH

DATE

*W08.10.03*

*00252A*

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 42054
<b>Description:</b> HINGE		<b>Part Number:</b> D3814-1
<b>Inspection Dwg:</b> D3814, <b>Rev:</b> A		<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.00	±.030	.998	—			
.50	±.030	.500	—			
4.00	±.030	4.016	—			
.31	±.030	.319	—			
.50	±.030	.500	—			
Ø.257	±.005 - .000	.260	—			
4.80	±.030	4.800	—			
4.67	±.030	4.670	—			
R.50	±.030	R.500	—			
R.13	±.030	R.130	✓			
2.29	±.030	2.290	—			
.38	±.030	.385	—			
2.09	±.030	2.090	—			
1.88	±.030	1.880	—			
.75	±.030	.756	—			
1.25	±.030	1.250	—			
1.25	±.030	1.250	✓			
.75	±.030	.750	—			
Ø.189	±.005 - .001	Ø.194	—			

<b>Measured by:</b>	<i>mf</i>
<b>Date:</b>	08/10/02

<b>Audited by:</b>	<i>DJP</i>
<b>Date:</b>	08/10/03

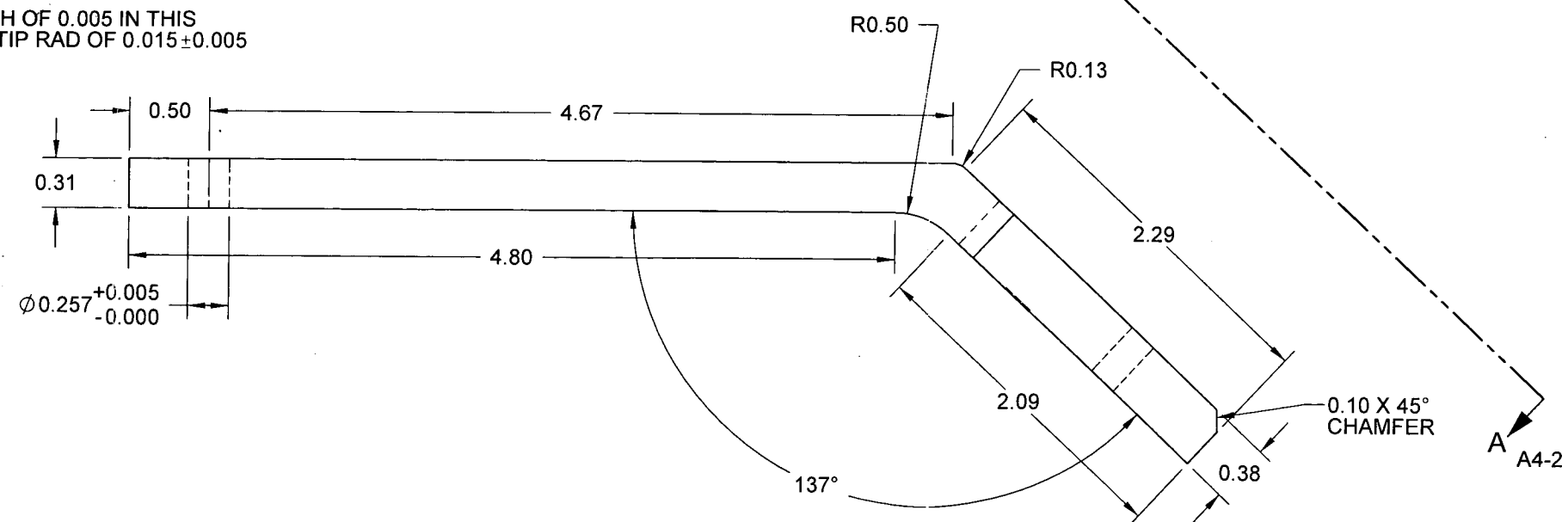
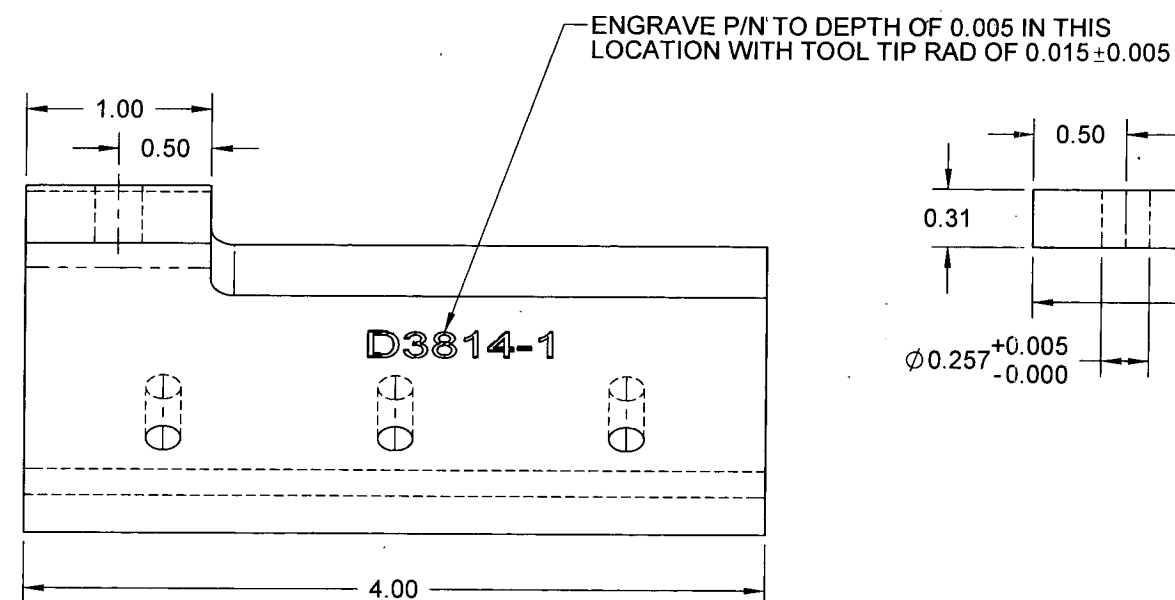
<b>Prototype Approval:</b>	
<b>Date:</b>	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

8 7 6 5 4 3 2 1

D  
C  
B  
A

D  
C  
B  
A



**D3814-1 HINGE, UPPER AIRFRAME**

**PRELIMINARY ISSUE**

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) PER AMS-QQ-A-200/8 (OR AMS 4160), (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.020 TO 0.030 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.44 lbs

A	NEW ISSUE		08.09.11
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.09.11		

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	REV. A
DRAWING NO. <b>D3814</b>	SHEET 1 OF 3
TITLE <b>HINGE</b>	SCALE NTS
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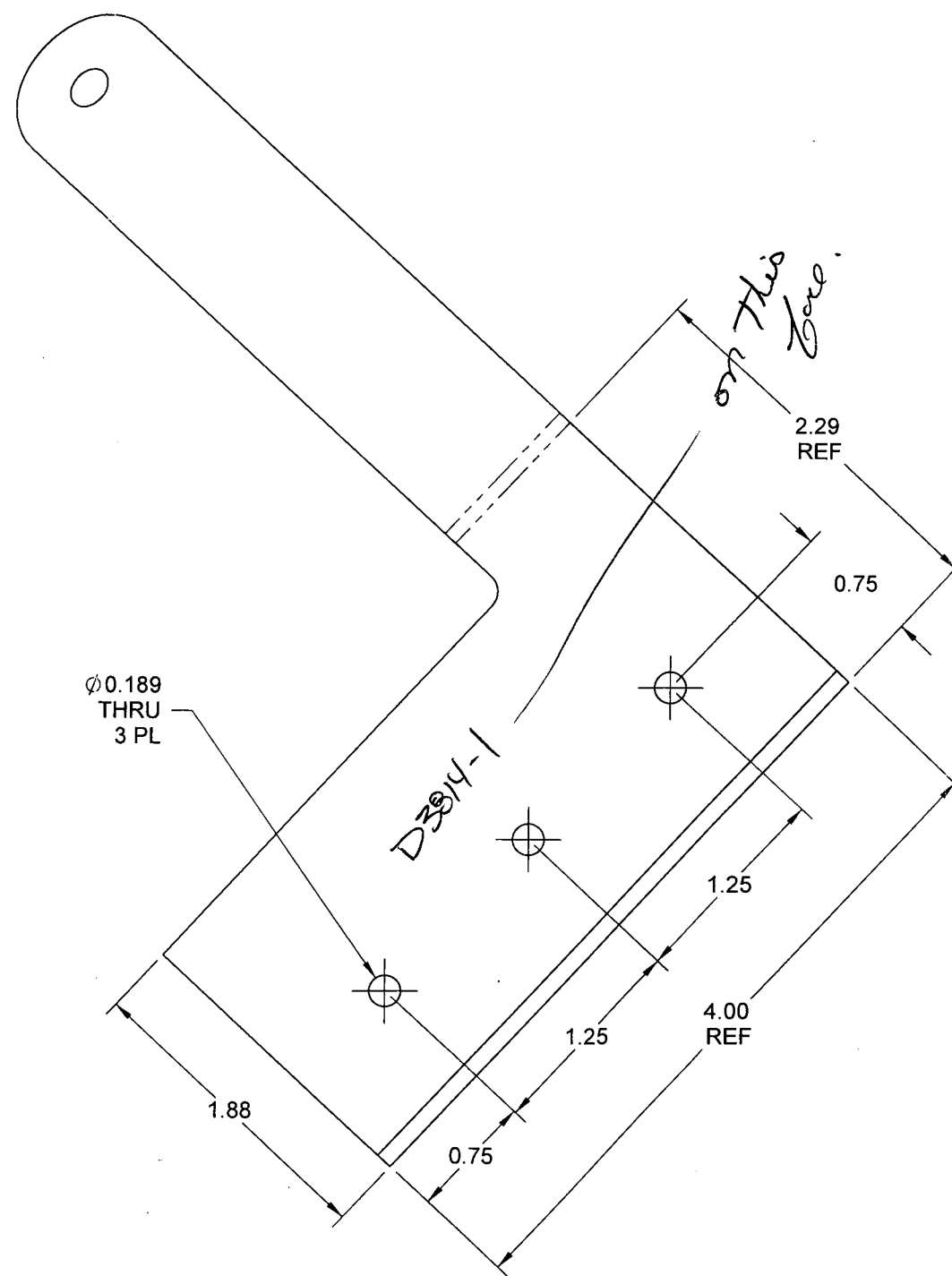
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VIEW A-A

B1-1

D3814-1 HINGE, UPPER AIRFRAME**PRELIMINARY ISSUE**

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
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APPROVED		TITLE	SCALE
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